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20NR-119-10
Job Sheet 191237



Part No: 20NR-119-10

Job Qty: 8 pcs

Part Name: Support Tubing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-119-10 Rev.2 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
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Container No: S173610



Part: 20NR-119-10

Job No: 191237

Serial No/Batch: S173610

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 04/18/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	8 pcs	5/10/19		0.00	0.80	Large Fab - 1		<i>EL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 5	8 pcs	5/10/19		0.00	0.00	QC 5 - 10		APR 18 2019 DAS 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	8 pcs	5/10/19		0.00	0.00	Packaging 3 - 1 - B4B		<i>EL</i>
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	8 pcs	5/10/19		0.00	0.00	QC 21 - SA - 21		APR 22 2019 DAS 21 9-89
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op
Descriptions: 100 - Fabricate as per drawing.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A519-T-0.680W0.095	ASTM A519 Seamless Alloy Steel Round Tubing, OD 0.680" X 0.095" Wall Thickness	3.7200 (.465 ea)	100-Large Fab - Welded Assy-1	<i>5157896</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	MT-A519-T-0.680W0.095	4	0	0

0.688 x 120

Part Specifications

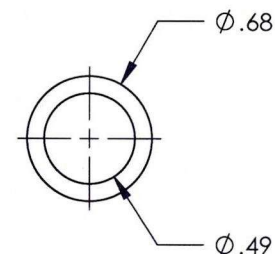
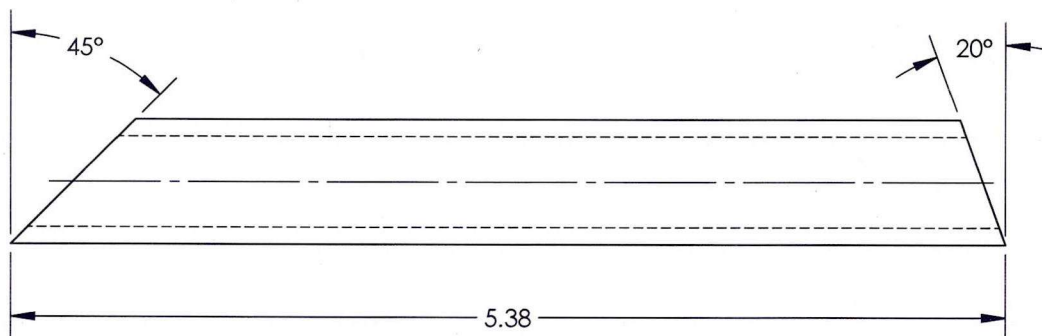
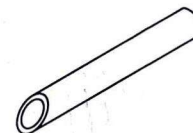
Specifications could not be found.

Plex 2/25/19 10:40 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM.	7/22/2013	CFS	
2	15-0358	UPDATED TO NEW DRAFTING STANDARDS. CH'D DIMS WAS (Ø.675) IS Ø.68, WAS (Ø.490) IS Ø.49.	11/13/2015	DPD	JAG

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191237 M.C.S
19-02-25



USED ON
20NR-119
8NR-119
20NR-86
8NR-86

DART AEROSPACE	
TITLE SUPPORT TUBING	
DWG NO. 20NR-119-10	REV 2
MAT'L 1018/1026 CDS	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .03 ANGLES ± 1°	FINISH SEE WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 12/1/1995 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-119-10	1	SUPPORT TUBING	1018/1026 CDS	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					